

Work Order ID 57711

April 14, 2010 10:09:54 AM



Page 1

Item ID: D3319-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10-4-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	Rev B								

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319
Deburr if necessary

☐ Dwg Rev:

B

☐ Prog Rev:

B

☐ 2-

B 10-4-15

(10)

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

B 10-4-15

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

5/10/2014

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57711

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Page 2

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Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Form using DT8326 & DT8261 as per Dwg D3319Rev: <u>B</u>								
150 	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

N/A

SD 10/04/19

410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

[illegible]

Page 3

Accept

[illegible]**Setup Start**

Stop

Cust Item ID:[illegible]

Customer:

Run Start

Date:

Tooling:

Date:

Date: _____

SPC (Y/N):

Date:

Stop

**Insp.
Stamp**

0.00

[illegible]

Large Fab

Large Fab

Memo

0.00

Large Fab

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev:

Qty	Part Number	Description	Batch	A/R
1	100-100-100	100-100-100	100-100-100	100-100-100

N/A	7560 Hardcoat Rod	M 113 328
-----	-------------------	-----------

0.00

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

0.00

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 57711

April 14, 2010 10:09:54 AM



Page 4

Item ID: D3319-3

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Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:00am

OVEN TEMPERATURE:

320°F

FINISH TIME:

7/21 10/05/25

10

8

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10

10-5-25

210

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: ☐TCCA-PDA, Dart Aerospace Ltd. ☐P/N: D3319-3, B/N: BXXXXX ☐For Product Eligibility see PDA05-18 ☐and Stock ☐Location: 547

10-5-26

10-5-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April 14, 2010 10:09:54 AM



Page 5

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/26
CL10/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:09:59 AM

Page 1

Work Order ID: 57711



Parent Item: D3319-3



Parent Item Name: Wearplate

Start Date: 14/04/2010

Required Date: 22/04/2010

Comments: IPP: A ☐ 05.05.12 ☐ New issue ☐ KJ/JLM ☐
IPP Rev:B Now on Waterjet 06-10-03 JLM ☐

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	96.0000	34.2358			
										<u>10-4-16</u>		
1010/1025 SHEET .048												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT19

114225

96

96

114225

10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	57711
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52				
74.420	+/-0.010	74.420				
62.770	+/-0.010	62.770				
52.890	+/-0.010	52.890				
30.790	+/-0.010	30.796				
8.690	+/-0.010	8.687	✓			
0.60	+/-0.030	.600	✓			
2.690	+/-0.010	2.696	✓			
2.940	+/-0.010	2.944	✓			
3.527	+/-0.010	3.526	✓			
4.518	+/-0.010	4.516	✓			
Ø0.190	+0.005/-0.001	.194	✓			
2.940	+/-0.010	2.939	✓			
2.940	+/-0.010	2.944	✓			
2.690	+/-0.010	2.692	✓			
5.063	+/-0.010	5.062	✓			
6.163	+/-0.010	6.162	✓			
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	.317 x .609	✓			
0.048	+/-0.010	.046	✓			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-4-16	Date: 10/04/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	EF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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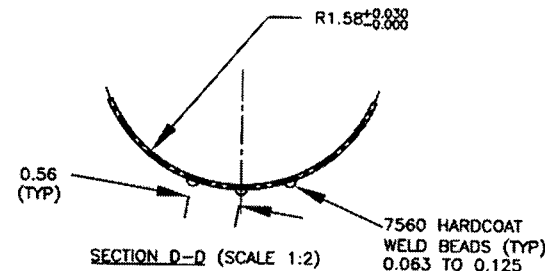
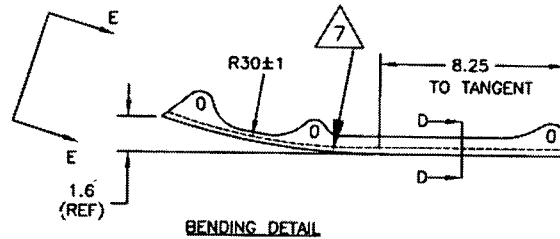
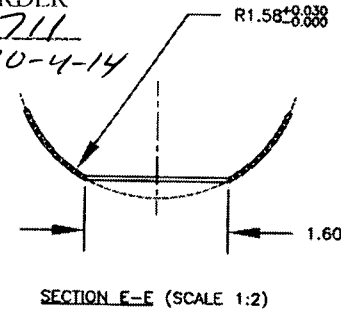
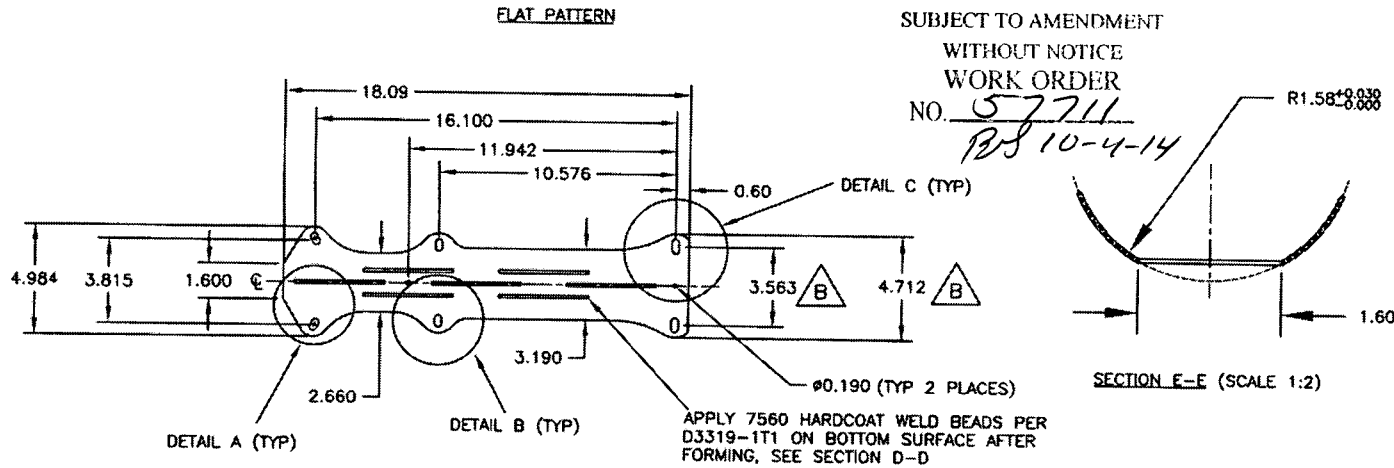
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SHOP COPY
RETURN TO
ENGINEERING

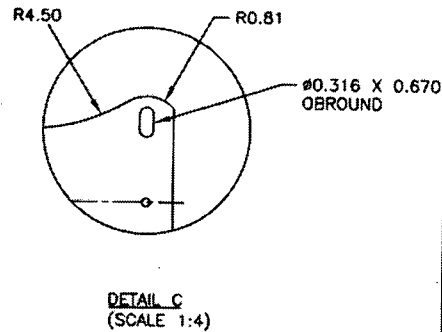
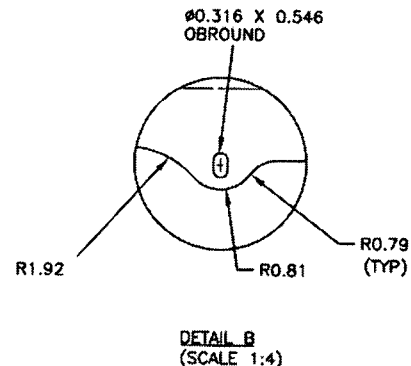
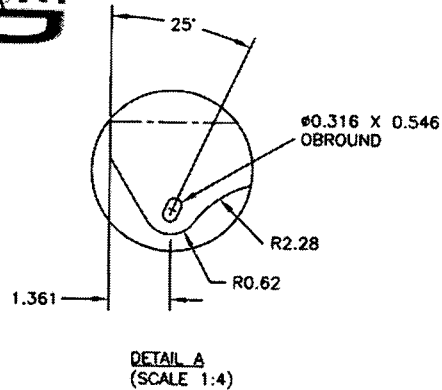
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 57711
BS 10-4-14

DART



RELEASED
05-09-30



DESIGN	DRAWN BY	DART AEROSPACE LTD
P41	P41	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
[Signature]	[Signature]	D3319
DATE	TITLE	SHEET 1 OF 5
05.06.06	WEARPLATE	SCALE 1:8
A	DATE	REVISION
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7

D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

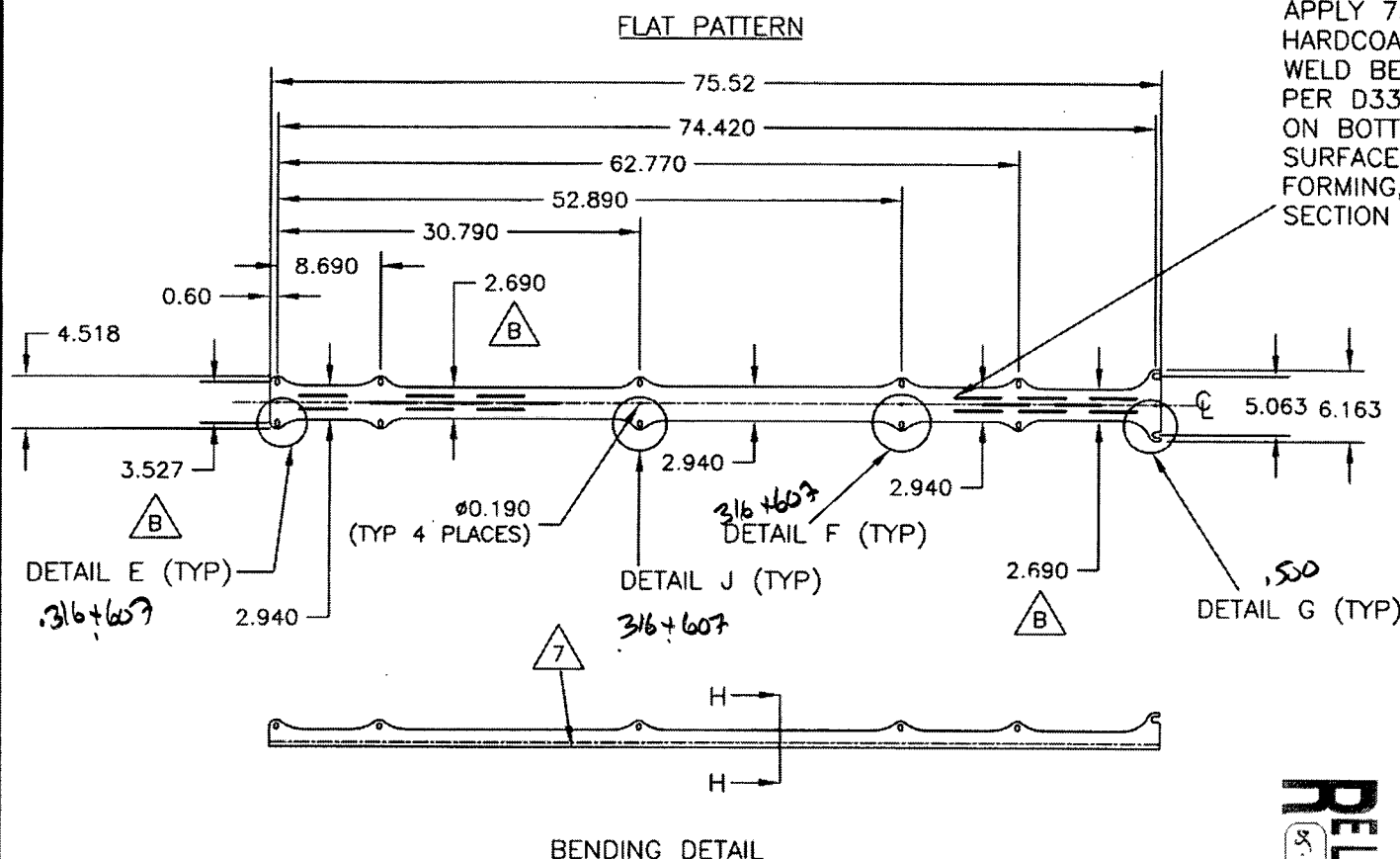
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>PH</i>	APPROVED <i>PH</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.06	TITLE D3319	REV. B
	WEARPLATE	SHEET 2 OF 5
		SCALE 1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

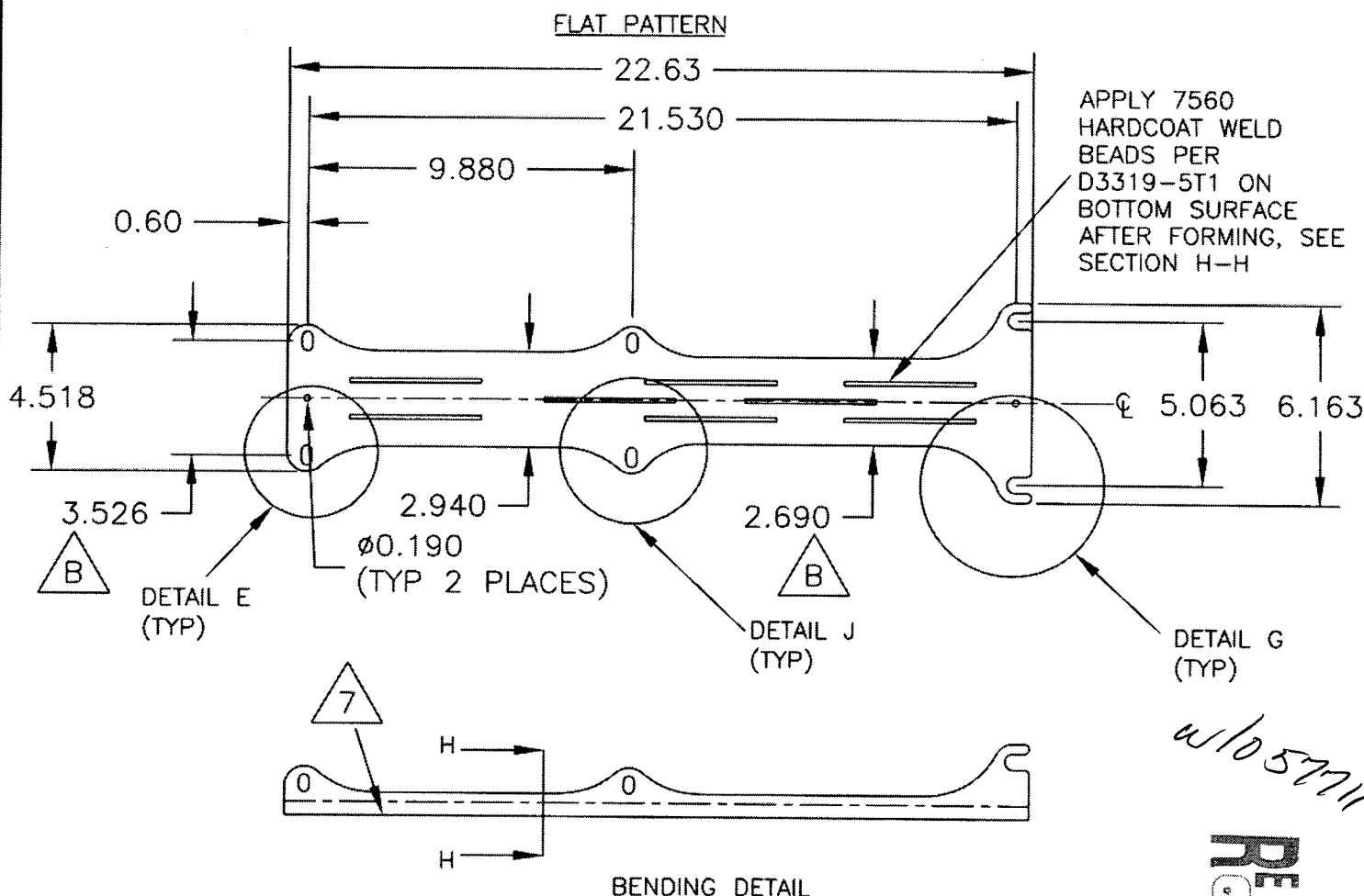
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	041	DRAWN BY	041	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
		WEARPLATE		SHEET 3 OF 5
				SCALE 1:5



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

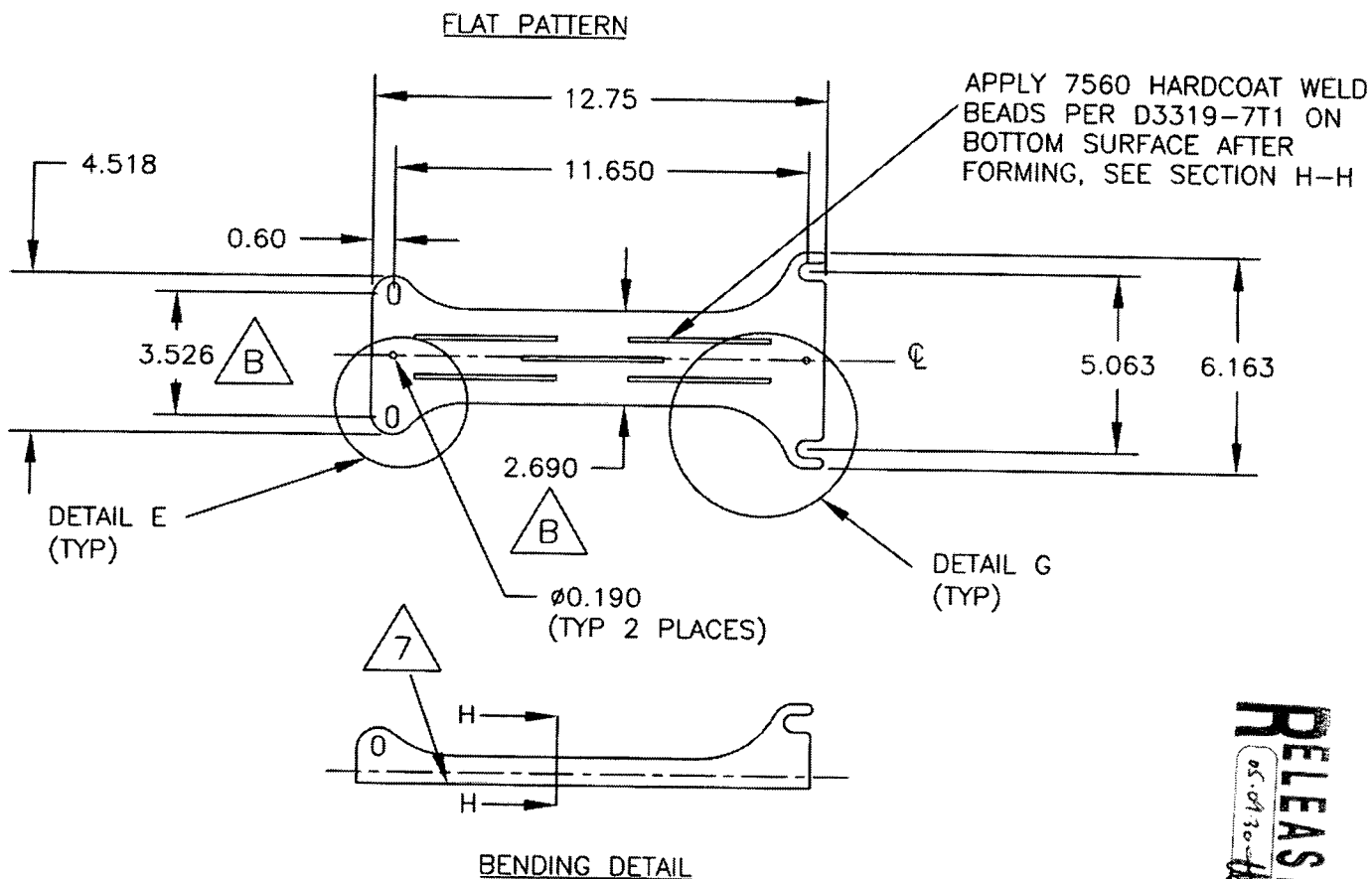
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
PH	PH	DRAWING NO.	REV. B	
CHECKED	APPROVED	D3319	SHEET 4 OF 5	
DATE		TITLE	SCALE	
05.06.06		WEARPLATE	1:5	

**RELEASED**
05-07-30-11

w/057711

D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

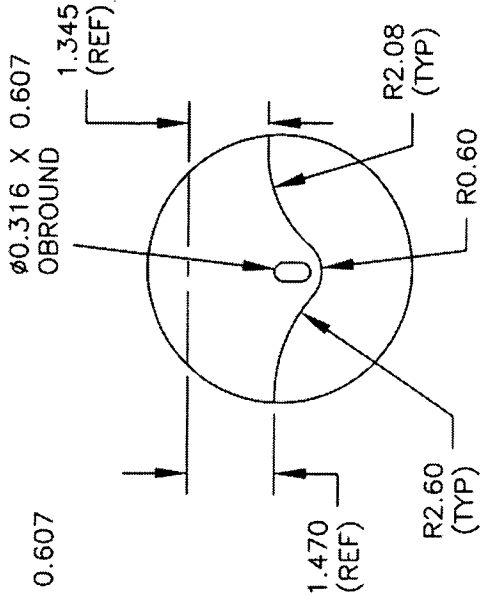
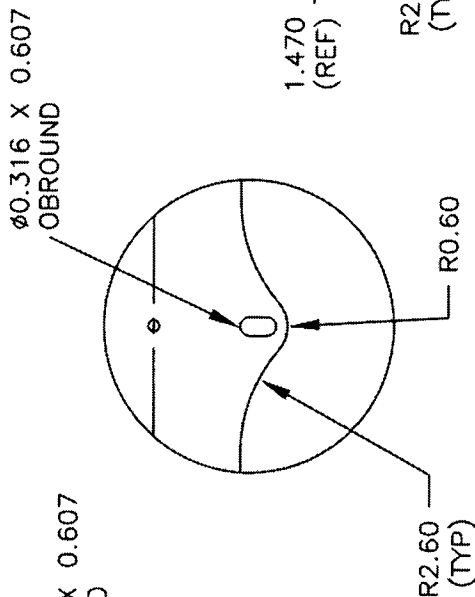
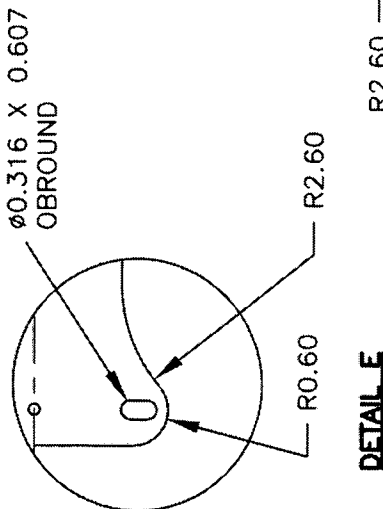
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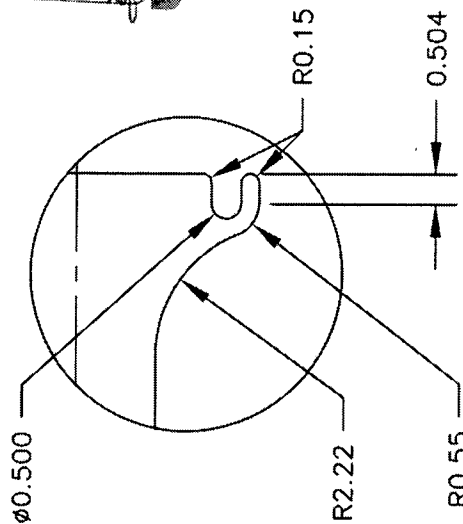
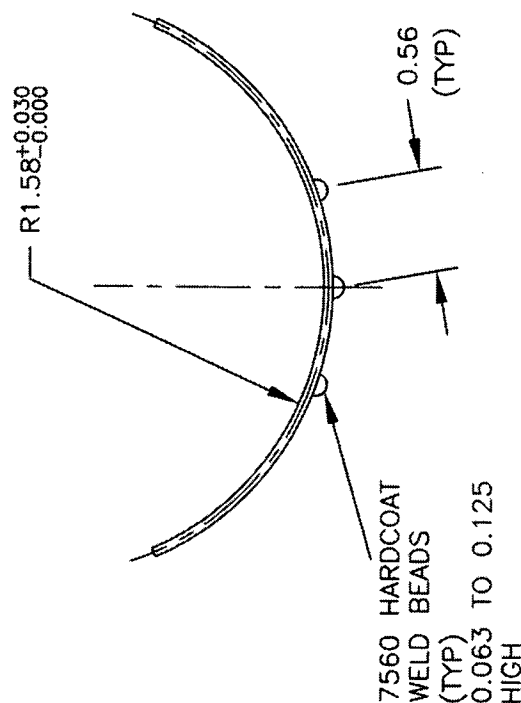
NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

**DETAIL J****DETAIL F****DETAIL E****RELEASED**
05.09.30

w/05774

**DETAIL G****SECTION H-H**
(SCALE 1:1)

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